

5/08

DART AEROSPACE LTD	Work Order:	21817 A
Description: Saddle billet	Part Number:	D6101-005
Drawing: D6101 Rev. A	Qty:	102 71

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	HA	04.10.27	100
2	PURCHASING	Issue P/O: 2007053 a) Description: Alluminum billet b) 5.00" x 8.250" x 2.50" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 5.00" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	U	04.10.28	100
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	CH	05/01/24	71
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	EP	05/02/07	71
5	STORES	Identify & stock	EP	05/02/07	71
6	EXPEDITING	Close W/O Cost / part 70.52 Syc 05/02/09 (71) ^{Inspect} level 21	HA	05.02.10	71

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

EC 01.05.16

RF
03.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

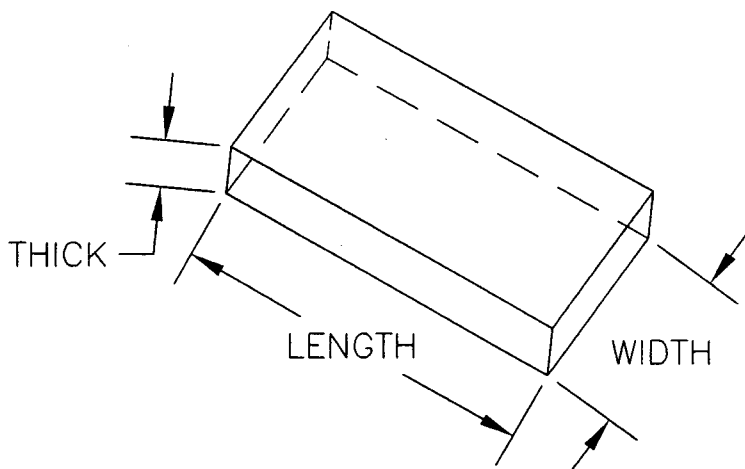
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CP*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 21817

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 27, 2004
02:15 pm

Work Order No	: 0021817	Department Code:	
Project Name	: D6101-005	Burden Flags	: NNNNNNNN
Project For	: WK508	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-005	Invoice Number	:
Description	: 7075-T7351 8.25X5.0X2.5	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 100	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 10-27-04	Actual Margin	: 0.000%
Est Finish Date	: 02-15-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

PECHINEY ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164

SHIP TO

COPPER & BRASS-TMX DIVISION
5450 E. HOME
FRESNO CA

93727

SHIP TO

COPPER AND BRASS SALES
P.O. BOX 5116
SOUTHFIELD MI

48086

COPPER&BR		J95403 1512		INCLUSION		SERIAL#: 20041217J95403		1	
CUSTOMER PURCHASE ORDER NO. & ITEM				PECHINEY ORDER NO.					
W18322				050-845401					
ALLOY	CLAD.	TEMPER	GAUGE	WIDTH	LENGTH				
7075	00	T7351	3.00000	48.500	144.500				
ITEM ORDERED									
MOLD PLATE-DIST GE									
SPEC PLATE, SAWED MILL									
CUSTOMER SPECIFICATION									
AMS-QQ-A-250/12									
PART NUMBER			B/L NUMBER			DATE SHIPPED			
091567-8			J95400			12/19/04			
WEIGHT SHIPPED		NO. OF PIECES		GOVT. CONTRACT NO.					
6,409		3							

CERTIFICATION

"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

PECHINEY ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26164

JODY S. THYER, LABORATORY SPECIALIST

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.									
309521	LT	2	***** T7351 70.2	70.2	58.1	58.2	***** 13.0	13.0	40.8	40.8									
ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS																			
MIL-STD-2154 100%SONIC TESTED MINUS DEAD ZONE CLASS A																			
ALSO CONFORMS TO BSS 7055, PS 21211, CL A SONIC																			
ALSO CONFORMS TO MMS 159J. ASTM B209-02, AMS 4078E																			
CHEM COMP	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN	MAX	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX	EACH MAX	TOTAL MAX
	SEE ACTUAL CHEMICAL COMPOSITION																		
	ALUMINUM REMAINDER																		

PECHINEY ROLLED PRODUCTS

CERTIFIED TEST REPORT

RAVENSWOOD, WV 26164

SHIP TO

COPPER & BRASS-TMX DIVISION
5450 E. HOME
FRESNO CA
93727

SOLD TO

COPPER AND BRASS SALES
P.O. BOX 5116
SOUTHFIELD MI
48066

COPPER&BR				MS3901 1512		PECHINEY ORDER NO.	
CUSTOMER PURCHASE ORDER NO. & ITEM				050-844883			
W15812	CLAD.	TEMPER	GUAGE	WIDTH	LENGTH		
7075	00	T351	3.00000	48.500	144.500		
ITEM ORDERED							
MOLD PLATE-DIST GE							
SPEC PLATE SAUED MILL							
CUSTOMER SPECIFICATION							
AMS-00-A-250/12							
PART NUMBER			BVL NUMBER			DATE SHIPPED	
091567-8			J3			07-07-04	
WEIGHT SHIPPED		NO. OF PIECES		GOVT. CONTRACT NO.			
8.400		4					

INCLUSION

CERTIFICATION

"Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

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RAVENSWOOD, WV 26164

JOE S. THYER LABORATORY SPECIALIST

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % TACS	
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.
222491	LT		70.6	70.9	59.0	59.5	11.5	12.0	39.9	40.0
***** T2351 *****										
M L-STD-2194 100%SONIC TESTED MINUS DEAD ZONE CLASS A										
ALSO CONFORMS TO BSS 7055 CL A SONIC										
ALSO CONFORMS TO MMS 159J. ASTM B209-02, AMS 4078E										